

[illegible]

Page 1

Accept

[REDACTED]

Setup Start

Stop

[illegible]**Cust Item ID:**[illegible]

Customer:

Run Start

Date: 11-09-29

Tooling:

Date:

Stop

Date:

SPC (Y/N):

Date:

[illegible]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3136-041 PAR #: N/A Fault Category: Small PAB / water Jet NCR: Yes No DQA: [Signature] Date: 11.10.07
11-5882 Resolution: Scrap Disposition: Scrap QA: N/C Closed: [Signature] Date: 11/10/11

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/09/09	#100	Found at inspection that qty x6 (all) have have "chatter" marks along the outside edges. (along where the water jet cut) R.C. <u>[Signature]</u> Process <u>[Signature]</u>	<u>[Signature]</u> 09/09/09	Scrap + Destroy + Refine qty x4 M 117329	11-10-03 <u>[Signature]</u>	S 11/05/03	<u>[Signature]</u> 09/24/09	<u>[Signature]</u> 11/10/03
				Qty x2 when deburring must be cleaned up				

NOTE: Date & initial all entries

Work Order ID 74430

Thursday, September 29, 2011 12:35:07 PM

Page 2

Item ID: D3136-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Window Assembly

Start Date: 9/29/2011 Start Qty: 6.00

Cust Item ID:

Required Date: 10/7/2011 Req'd Qty: 6.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

0.00



Thermoform

THERMOFORMING MACHINE

Memo

0.00

Thermoforming Machine

1-Thermoform as per Dwg D3136 and Folio FTA006 Dwg
Rev. E ☐ Folio Rev. C ☐ 2- Engrave Part # and
Batch # , and affix labels ☐ (D3108-9)

x6

Dk.
11/10/05

140

0.00



QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

x6

Dk.
11/10/05

150

0.00



QC

QC8- Inspect parts - second check

Memo

0.00

Quality Control

S. Miller

(x6)

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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NOTE: Date & initial all entries

Work Order ID 74430

Thursday, September 29, 2011 12:35:07 PM



Page 4

Item ID: D3136-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Window Assembly

Start Date: 9/29/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 10/7/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/10/6

ME
11-10-6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, September 29, 2011 12:35:02 PM

Page 1

Work Order ID: 74430

Parent Item: D3136-041

Parent Item Name: Window Assembly

Start Date: 9/29/2011

Required Date: 10/7/2011

Start Qty: 6.00


Required Qty: 6.00

Comments: IPP B ☐ 04.02.04 ☐ Reformat ☐ KJ/DS ☐
 IPP C Thermoform in house 05/07/2007 DL
 IPP D Rev E 07.09.28 EC verified by: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3108-9		Manufactured	No			100	Each	606.0000	2	12			
													
Decal													

Location	Loc Qty	Loc Code
ST033	606	
34554	106	
46546	500	

MACRLICS.125		Purchased	No			170	sf	137.0934	4.25	26.84211			
													
1/8" Polycast II Sheet													

Location	Loc Qty	Loc Code
MAT	101.8467	
117431	101.8467	
MAT018	32.2467	
117324	32.2467	
MAT019	3	
115338	3	

OK
11/10/05

B11-9-29

117431

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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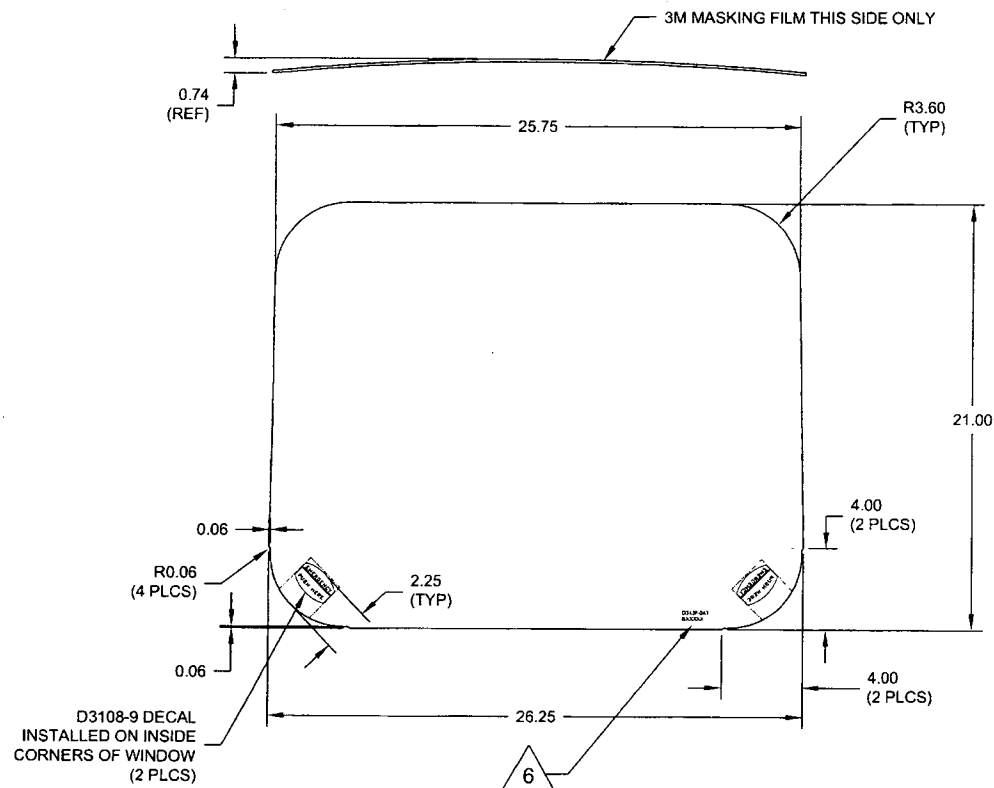
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D3136-3 WINDOW
D3136-043 WINDOW ASSEMBLY
 (INCLUDES D3108-9 DECALS)

NOTES:

- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425 OR PLEXIGLAS G
 CLEAR CAST ACRYLIC SHEET PER LP-391 TYPE 1 GRADE C, 0.125 THICK
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) REMOVE SHARP EDGES
- 6) IDENTIFICATION: ENGRAVE P/N "D3136-043" AND B/N ON LOWER EDGE
 USE 0.125" HIGH LETTERS TO MAXIMUM DEPTH OF 0.005"
- 7) WEIGHT: 2.61 +/- 0.58 LBS
- 8) FORMING PROCESS: a) HEAT LARGER PIECE TO 250° F
 b) DRAPE OVER D3136-T1 MOLD & CLAMP
 c) LEAVE FOR 2 HOURS COVERED WITH INSULATED BLANKETS

RELEASED
 07.09.22

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3136	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		WINDOW ASSEMBLY	1:
DATE	07.09.10	COPYRIGHT © 2002 BY DART AEROSPACE LTD	
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